

**Work Order ID 52303**

Page 1

Tuesday, September 22, 2009 2:32:42 PM

Item ID: D2885

Accept



Setup Start



Revision ID: B

Stop



Item Name: Saddle Spacer

Start Date: 9/23/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan: *PLM*

Date: 09/9/22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D2885	Rev B	

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2885

 Dwg Rev: *B* Prog Rev: *B* 2-

Deburr if necessary

*B 9-10-17*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

*B 9-10-17*

Quality Control

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

*→ 809/10/19**cont'd**(+72) f*

Quality Control

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Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 40.00



Customer:

**Reference:**

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**Sequence ID/  
Work Center ID****Operation  
Description****Set Up/  
Run Hours****Draw  
Number****Draw  
Rev.****Plan  
Code****Accept  
Qty****Reject  
Qty****Reject  
Number****Insp.  
Stamp**

130



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

88-10-20.

0.00

Hand Finishing

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

150



Packaging

Packaging

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

Memo

0.00

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Start Date: 9/23/2009 Start Qty: 40.00



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Customer:

**Reference:**

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC21- Final Inspection - Work Order Release	0.00							<i>09/10/21 JF</i>
QC	Memo	0.00							<i>MF 09-10-21</i>
Quality Control									



QC

Memos

Quality Control

# Picklist Print

Page 1  
1

Tuesday, September 22, 2009 2:32:41 PM

Work Order ID: 52303



Parent Item: D2885RevB



Parent Item Name: Saddle Spacer

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased		No		100	sf	110.7094	1.0821	0.000		HB9-10-17

6061-T6 .080 Sheet

Warehouse                    Loc Qty                    Loc Code

Location

Main Warehouse

MAT	110.7094	
107904	0.02	
110254	2.5	
110630	38.0926	
112040	0.0437	
112141	33	
112512	37.0531	112-812

DART AEROSPACE LTD	Work Order:	52303
Description: Saddle Spacer	Part Number:	D2885
Inspection Dwg: D2885	Rev: B	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## **X First Article      □ Prototype**

Measured by:	<u>RB</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	9-10-17	Date:	09/10/17	Date:	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	06.08.30	New Issue	KJ/JLM	SJ

SHOP COPY

RETURN TO

ENGI

UNCONTR DART

SUBJECT TO

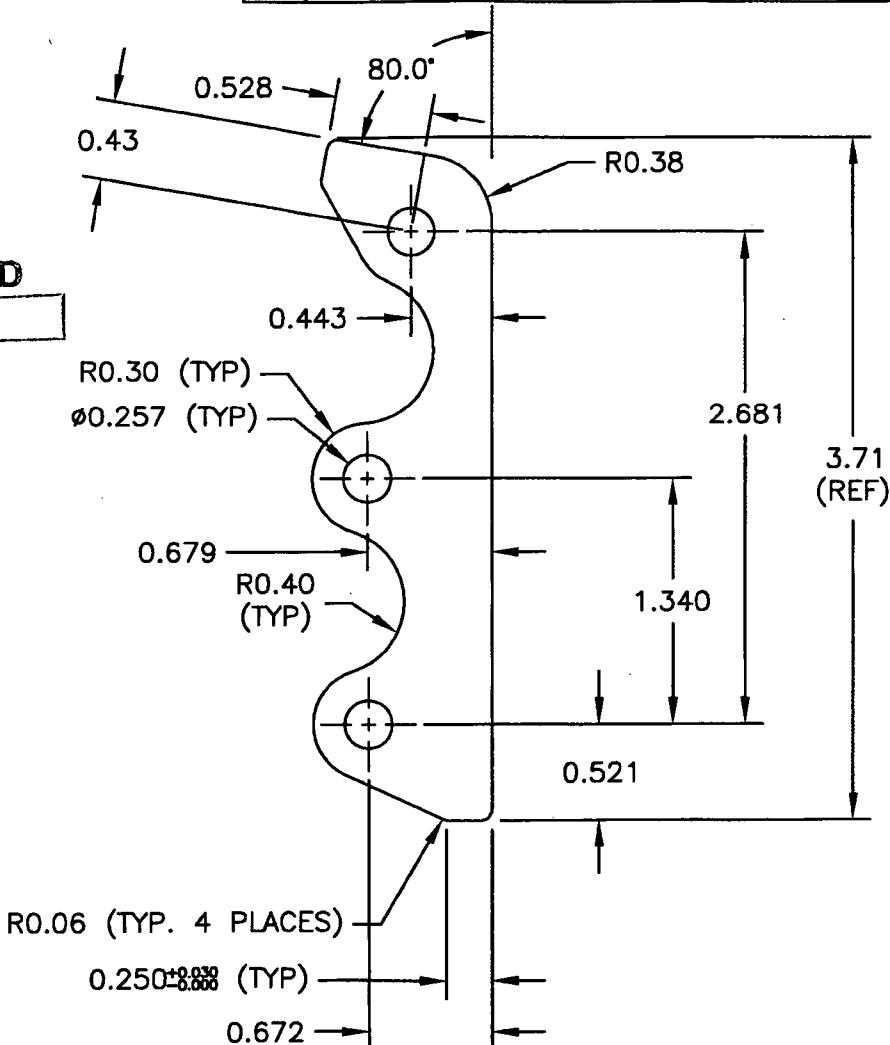
WITHOUT NOTICE  
WORK ORDER

NO. 52302

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
PH		D2885
DATE	TITLE	SCALE
06.05.29	SADDLE SPACER	1:1
A	99.04.01	NEW ISSUE
B	06.05.29	ADD 6061-T6 MATERIAL

RELEASED

6-6-90



NOTES:

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027)  
0.080" THICK (REF DART SPEC M6061T6S.080)  
OR  
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016)  
0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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